

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014647**Date Inspected:** 12-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1: CB15.

This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time when this QA was present.

Bay 8: CB17.

This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time when this QA was present.

Trial Assembly:

CB9:

This QA Inspector observed the following work in progress:

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Repair welding of weld joint no: CB202A-009-006. Welding process was identified as Shielded Metal Arc Welding (SMAW). Welder is identified as 066002. ZPMC Quality Control (QC) is identified as Li Jia. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-FCM-Repair.

Repair welding of weld joint no: CB202A-009-018. Welding process was identified as Flux Cored Arc Welding (FCAW). Welder is identified as 048696. ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-Repair. Refer attached photo for reference.

The above two welds are repair welded as per WRR: B-WR-13530 Rev-0 Dt: 06/08/10. Repair welding was done to correct the mis-alignment of bottom panel of CB9 & OBG Seg 8AE.

SMAW of weld joints CB202A-009-021, 022 & 009. Welders are identified as 069896 & 067571. ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114.

SMAW (after back gouging) of weld joints CB202A-009-001, 003 & 013. Welders are identified as 067665, 066179 & 037723. ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2212-TC-U4b-FCM-1. Refer attached photo for reference.

CB10:

This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time when this QA was present.

Outside Yard:

CB11, CB12, CB13, CB14 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer